

Date: Friday, 24/10/2008 3:31:37 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : END FITTING ASS'Y
 Job Number : 42948
 Estimate Number : 13345
 P.O. Number :
 This Issue : 24/10/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D3763041
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D3763 REVB
 Previous Run : 41158 Project Number : N/A
 Material :
 Due Date : 03/11/2008 Qty: 10 Um: Each
 Written By :
 Checked & Approved By : 2008.10.24
 Comment : Est Rev:A 08-05-20 new issue DD verified by:ec
 Est Rev:B 08-07-18 revB as per dwg DD verified by:EC
 Est Rev:C 08-08-11 add chemical coat and qc3 DD verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

2.0 D37631 End Fitting



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

End Fitting

batch: B42732 = 10x

SP 09.02.05

3.0 D37633 Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Tube

batch: B42733 = 10x

SP 09.02.05

4.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-make a 0.063" chamfer on D3763-1 fitting before ass'y

2-assemble as per dwg D3763 using locating pin DT9039

*****ensure locating pin is in 0.221" hole*****

3-weld as per dwg D3763 QSI004

Alum. rod Batch: M 104855

SP 09.02.05

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 24/10/2008 3:31:38 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END FITTING ASSY

Job Number: 42948

Part Number: D3763041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

RF 09/02/05 (10)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/05 (10)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FZ 09/02/05 (10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 9/2/05 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: _____

C 9/2/06 (10)

10.0

QC21

FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

AD 09/02/05 (10)

Job Completion



C 09/02/04

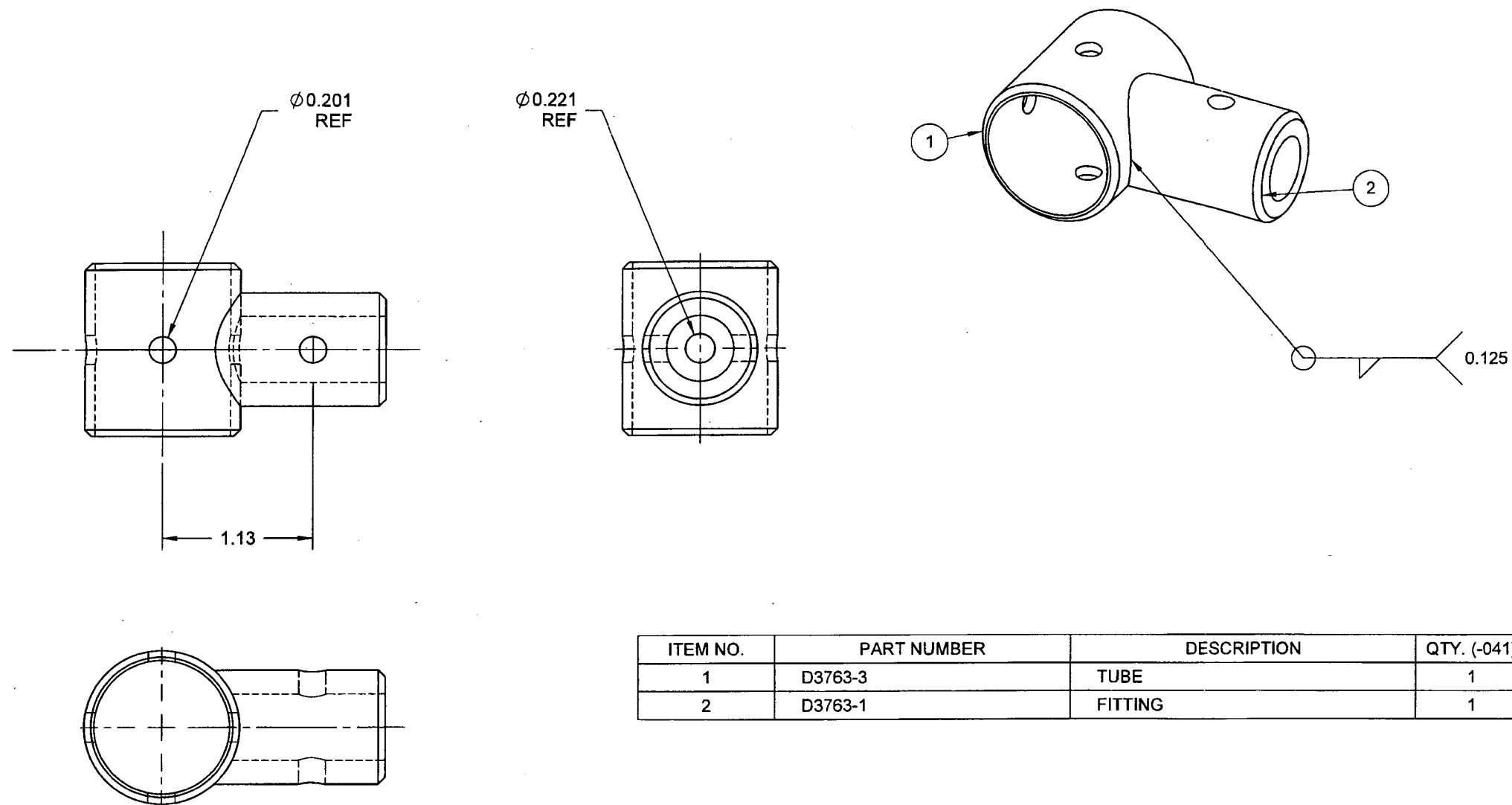
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3763-041 END FITTING ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs
- 8) WELD: PER DART QSI 004

B	CHANGE HOLES SIZE, ADD -7 PART AND -045 ASSY	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3763	SHEET 1 OF 9
APPROVED		TITLE	SCALE
DE APPR.		END FITTING	NTS
DATE	08.06.23	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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08.07.10/14/15

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WORK ORDER
NO. 42948